

Work Order ID 82550

April-03-12 8:31:07 AM

82550

Page 1

Item ID: D2804-2

Revision ID:

Item Name: Bracket

Start Date: 03/04/2012 Start Qty: 6.00

Required Date: 17/04/2012 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

Date: 12/04/03 Tooling:

Date:

QC:

Date: 12/04/03 SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2804	Rev C
-------	-------

100

100

FLOW WATER JET

0.00

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per File D2804-1-2 BLANK

6061 .500 x 10.00

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110

110

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA103

120

120

QC2- Inspect parts off machine FA1/FA1B

0.00

QC

Memo

0.00

Quality Control

PTO-D

W/O: 82550		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2804-2 PAR #: _____ Fault Category: Small Tab ^{WS} NCR: Yes No DQA: AK Date: 12/06/07
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: CK Date: 12/07/07

NCR: 12-1478		WORK ORDER NON-CONFORMANCE (NCR) ^{WS}						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/05/30	100	Deepness of the STOP SOCKET is 0.255 IN TWO PART and is due TO Blank Thickness Variation. RC " material properties	<u>CP</u> 12.05.30 QSI/VR	FACE SURFACE 0.005 TO BRING INTO TOLERANCE.	12/05/30 <u>PD</u>	<u>h.a</u> 12/06/04	<u>CP</u> 12.05.30 QSI/VR	<u>h.a</u>

NOTE: Date & initial all entries

Work Order ID 82550

April-03-12 8:31:07 AM

82550

Page 2

Item ID: D2804-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bracket

Stop

NS2

Start Date: 03/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

B.A 12/06/04

QC

Memo

0.00

Quality Control

6

0

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

6

MG 126.4

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

150

6X 12/06/04

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82550

April-03-12 8:31:07 AM

82550

Page 3

Item ID: D2804-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bracket

Stop ***NS2***

Start Date: 03/04/2012 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 17/04/2012 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location <i>G-A</i>	0.00							
160									
Packaging	Memo	0.00				<i>GK</i>			<i>12/06/05</i>
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/6/05

*unc
12-06-05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-03-12 8:31:10 AM

Page 1

Work Order ID: 82550

82550

Parent Item: D2804-2

D2804-2

Parent Item Name: Bracket

Start Date: 03/04/2012

Required Date: 17/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP A00.11.06New IssueEC

IPP B06.05.30 Blanks on wtjetEC

IPP Rev:C As per Rev C 06-11-09 JLM

IPP Rev:D Removed Tumbling 08-09-10 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X10.00 0		Purchased	No				f	22.5000		4.5			

M6061T6B0 500X10 000

**

6061-T6 Bar .500 x 10.00

Location

Loc Qty

Loc Code

MAT004

22.5

120421

22.5

~~120421~~
121660

Handwritten signature
JM
12-5-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	82550
Description: STA 155 Bracket		Part Number:	D2804-2
Inspection Dwg: D2804 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	0,126	✓		VERN	PHD-01
0.125	+/-0.010	0,125	✓		"	"
R0.125	+/-0.010	0,125	✓		Rad gauge	
0.250	+/-0.010	0,250	✓		VERN	PHD-01
0.250	+0.000/-0.005	0,250	✓		PHD-09	
0.875	+0.000/-0.001	0,875	✓		VERN	PHD-01
R0.062	+/-0.010	0,062	✓		Rad gauge	
Ø0.757	+0.005/-0.000	0,757	✓		VERN	PHD-01
R0.625	+/-0.010	0,625	✓		Rad gauge	
12.304	+/-0.005	12,304	✓		HASS 1	
Ø0.507	+0.000/-0.001	0,5065	✓		VERN	PHD-01
0.437	+0.000/-0.001	0,4365	✓		"	"
0.608	+0.000/-0.001	0,608	✓		"	"
Ø0.191	+0.005/-0.000	0,191	✓		Pin gauge	
1.420	+0.001/-0.001	1,420	✓		VERN	PHD-01
0.250 deep	+/-0.010	0,245	✓		PHD-09	
6.933	+/-0.005	6,933	✓		HASS	
7.578	+/-0.005	7,578	✓		HASS	
0.500	+/-0.010	0,504	✓		VERN	PHD-01

Measured by: RD/127	Audited by: H.A	Prototype Approval:	N/A
Date: 12/05/30	Date: 12/06/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

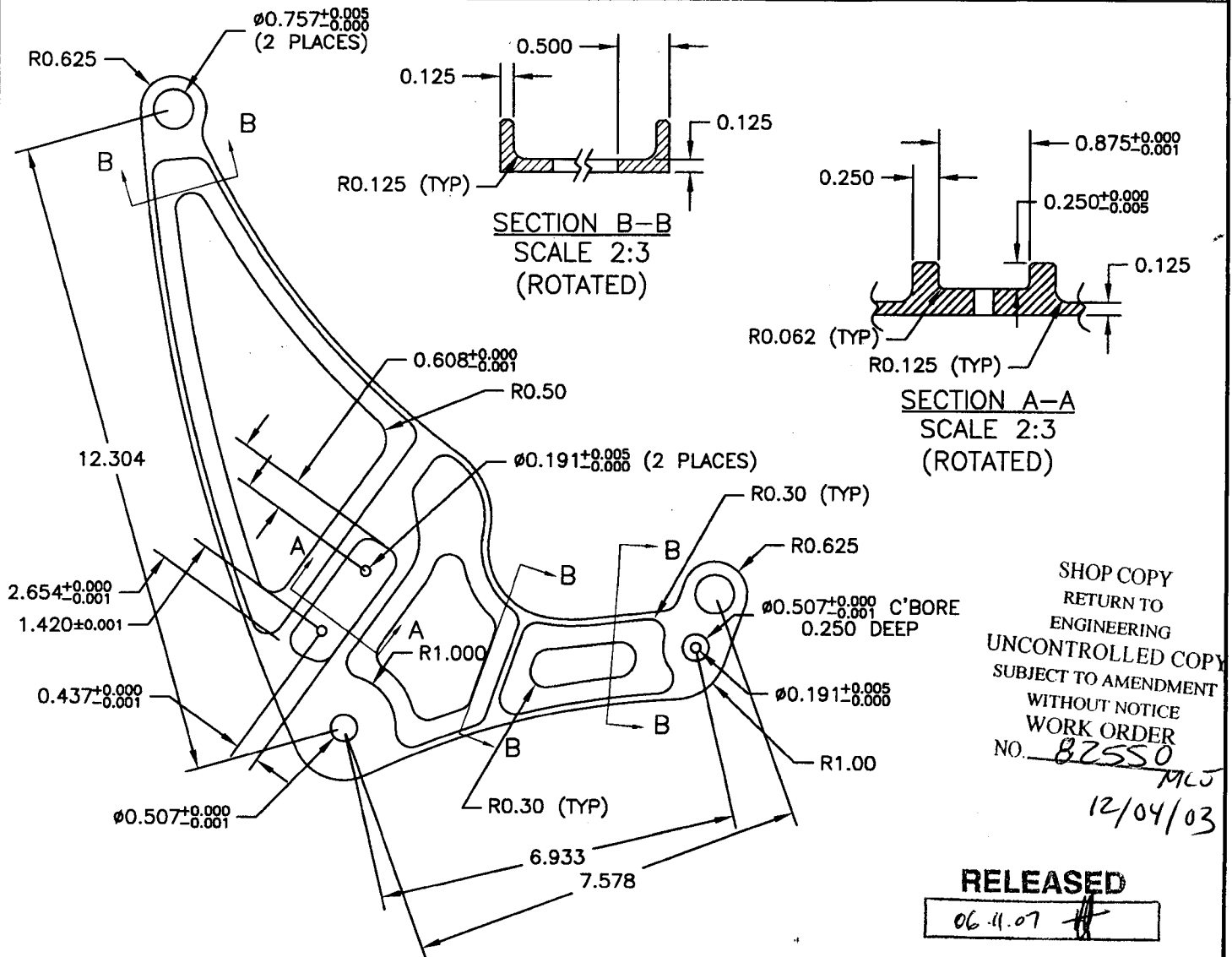
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

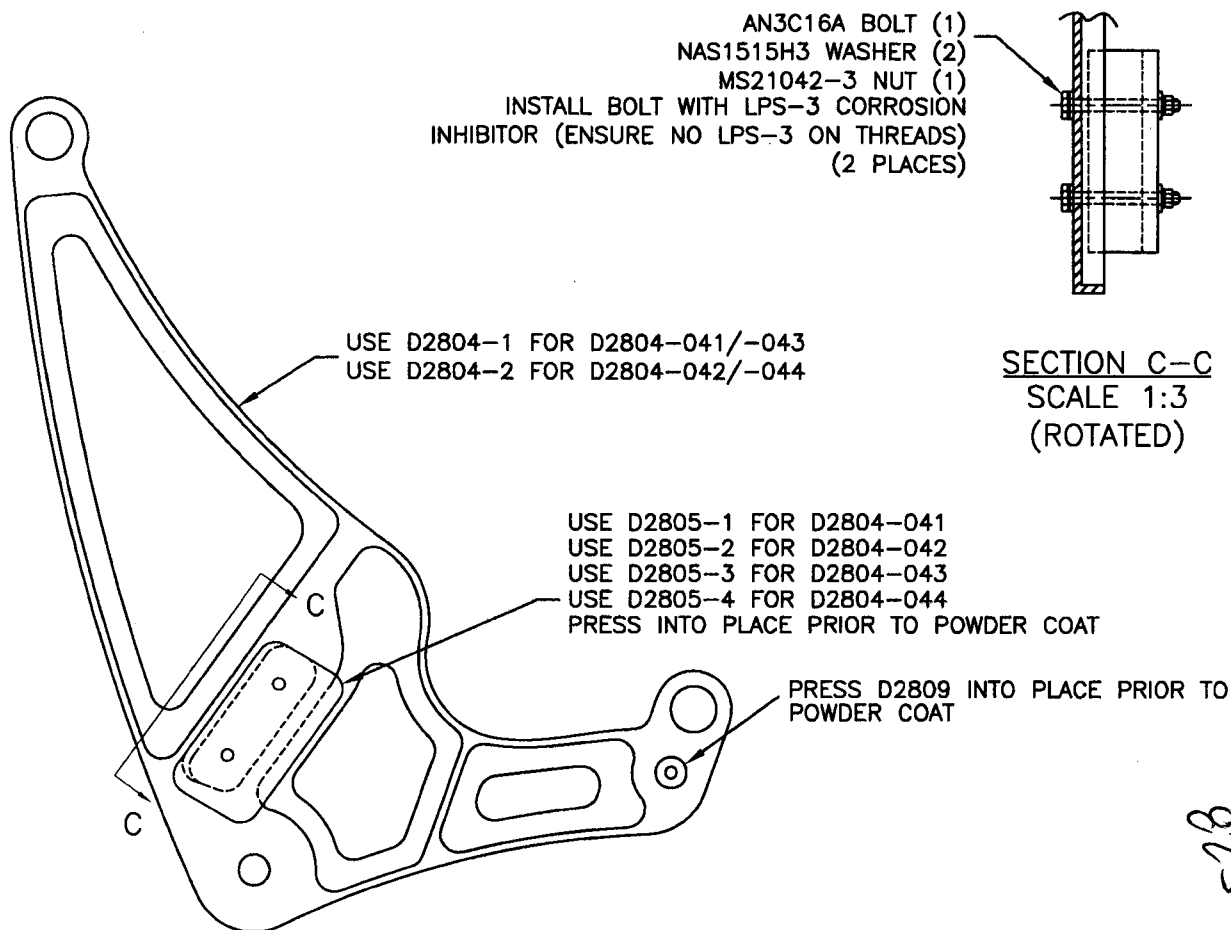
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



SECTION C-C
SCALE 1:3
(ROTATED)

02528

RELEASED

06.11.07 *[Signature]*

D2804-041/-043 BRACKET ASS'Y (SHOWN).

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries